

Date: Monday, 11/12/2007 11:46:14 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: HI-STEP LEG ASSEMBLY		
Job Number	: 35625						
Estimate Number	: 10385						
P.O. Number	:			Part Number	: D3065041		
This Issue	: 11/12/2007	S.O. No.	:	Drawing Number	: D3065 REV B		
Prsht Rev.	: NC			Project Number	: N/A		
First Issue	: / /	Type	: SMALL /MED FAB	Drawing Revision	:		
Previous Run	: 35622			Material	:		
Written By	:			Due Date	: 12/19/2007		
Checked & Approved By	: <u>J.D. 11.12</u>			Qty:	SO <u>100</u> Um: Each		
Comment	: Est Rev: JC 02.11.01			Incorporated D3066-1 IPP KJ/RF			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D30651	Step Spacer  Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s) Step Spacer B 35614
2.0	D30653	Step Spacer  Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s) Step Spacer B 35615
3.0	D30655	Step Leg  Comment: Qty.: 2.0000 Each(s)/Unit Total : 200.0000 Each(s) Step Leg B 35620
4.0	D30657	Step Spacer  Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s) Step Spacer B 35616
5.0	MS20470AD44	Rivet, Universal Head  Comment: Qty.: 30.0000 Each(s)/Unit Total : 3000.0000 Each(s) Rivet, Universal Head Pick: Qty Part Number Description Batch 30 MS20470AD4-4 Rivet

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HI-STEP LEG ASSEMBLY

Job Number: 35625

Part Number: D3065041

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



P1C

Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D3065 and Identify as D3065-041

Bosby/16

MF 08-04-16

50

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP
S 08/04/17 X(0) counter

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: int

08-04-17 50

9.0 QC21

FINAL INSPECTION/W/O RELEASE



08/04/1870

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-04-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

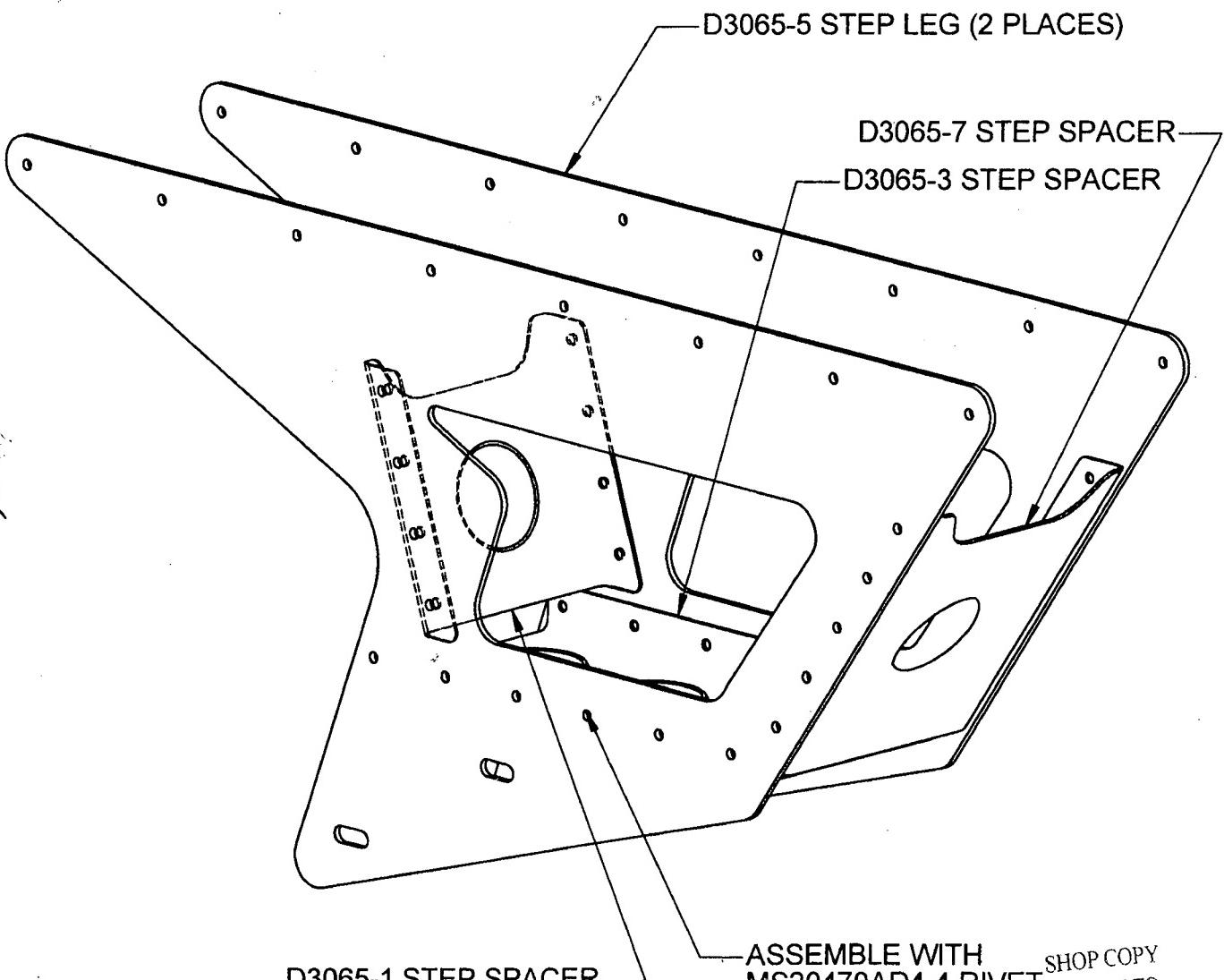
Part No: D3065-041 PAR #: WA Fault Category: Prod Fab Ass! Med 5000 NCR Yes No DQA: D Date: 08/04/18
 J356-591 QA: N/C Closed: D Date: 08/04/21

WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/04/16	6.0	D3065-041 is missing 3 rivets, And 1 hole in the D3065-1 is oversized due to drilling ; replacing A rivet. Found upon inspection, Employee did not verify work for completeness.	QSIU12	- Add 3 rivets to complete Assembly, and replace the D3065-1, and scrap the existing one on the ASS'Y MS 20470 AD4-4 B35614 QTY 3 D3065-1 B35614 QTY 1	EB 08/04/17 MF 08-04-17 08/04/17	6	QSIU12	QSIU12
08/04/16	6.0	1x D3065-041 is missing 1 rivet pressed. Rivet is installed, but not pressed. 1x D3065-041, the(1) rivet in the ASS'Y appears to be very small, thin, and flat, after being pressed. Does <u>not</u> look like the others.	QSIU12	- Complete the ASS'Y, and verify all work, and parts. (Inspect) before inspection. Carefully remove rivet to inspect its hole size on the D3065-1	EB 08/04/17 MF 08-04-17 08/04/17	6	QSIU12	Q80416
			QSIU12		EB 08/04/17 MF 08-04-17 08/04/17	6	QSIU12	Q80416

NOTE: Date & initial all entries

DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 1 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

RELEASED*06.06.20 [Signature]***D3065-041 STEP LEG ASSEMBLY**

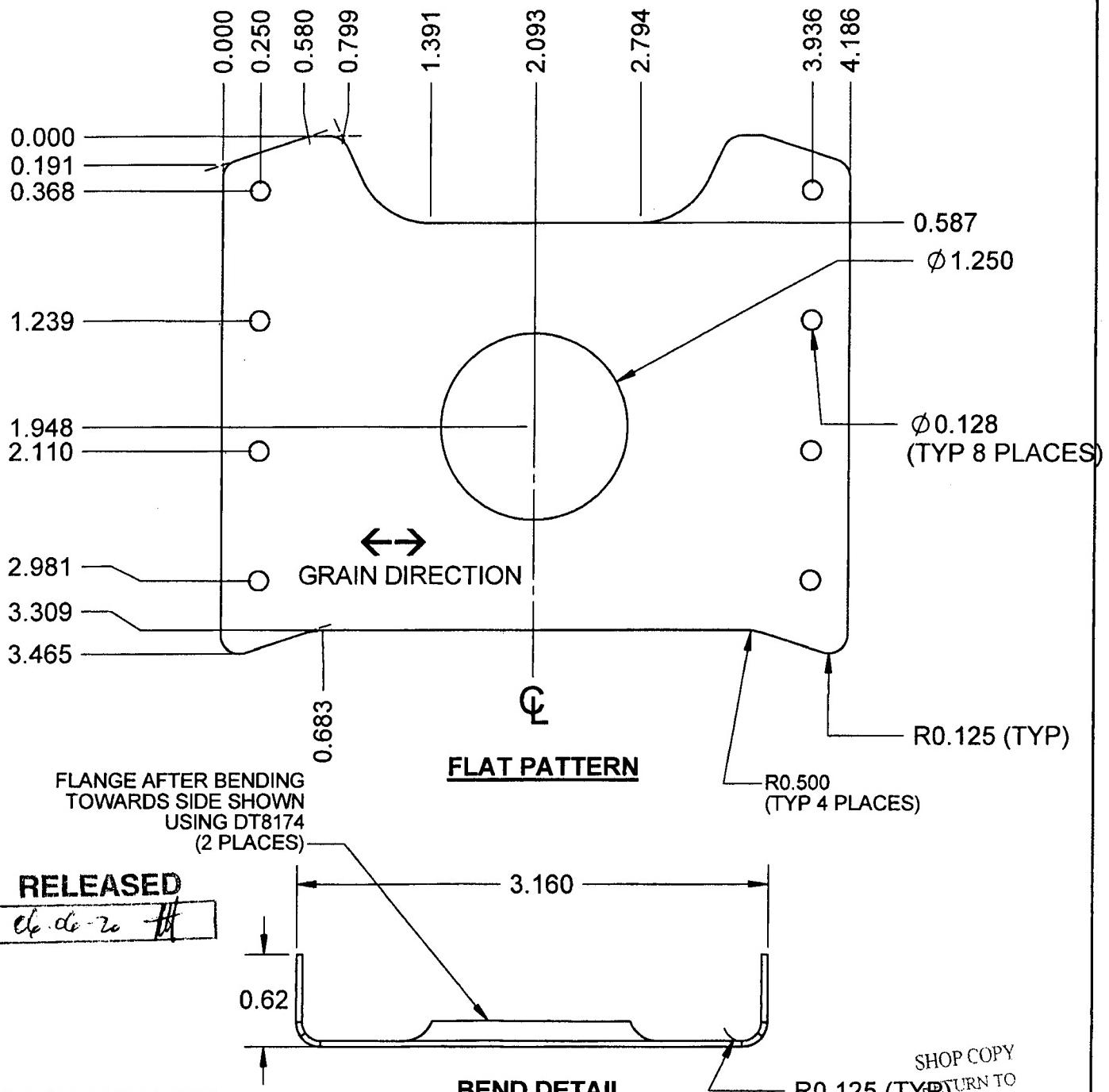
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CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. D3065	REV. B SHEET 2 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1

**D3065-1 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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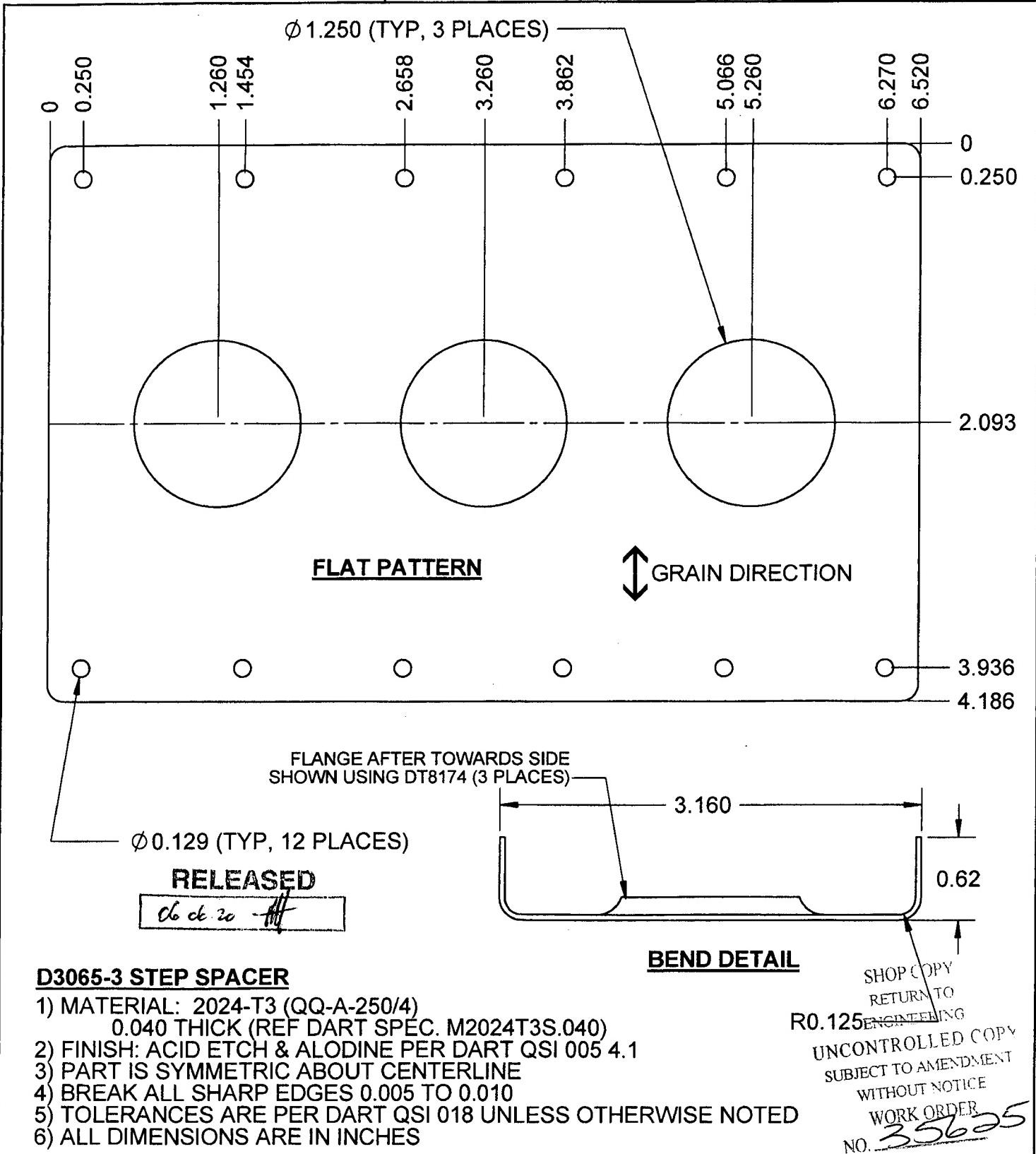
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DATE 06.05.23	TITLE STEP LEG ASSEMBLY	SCALE 1:1	

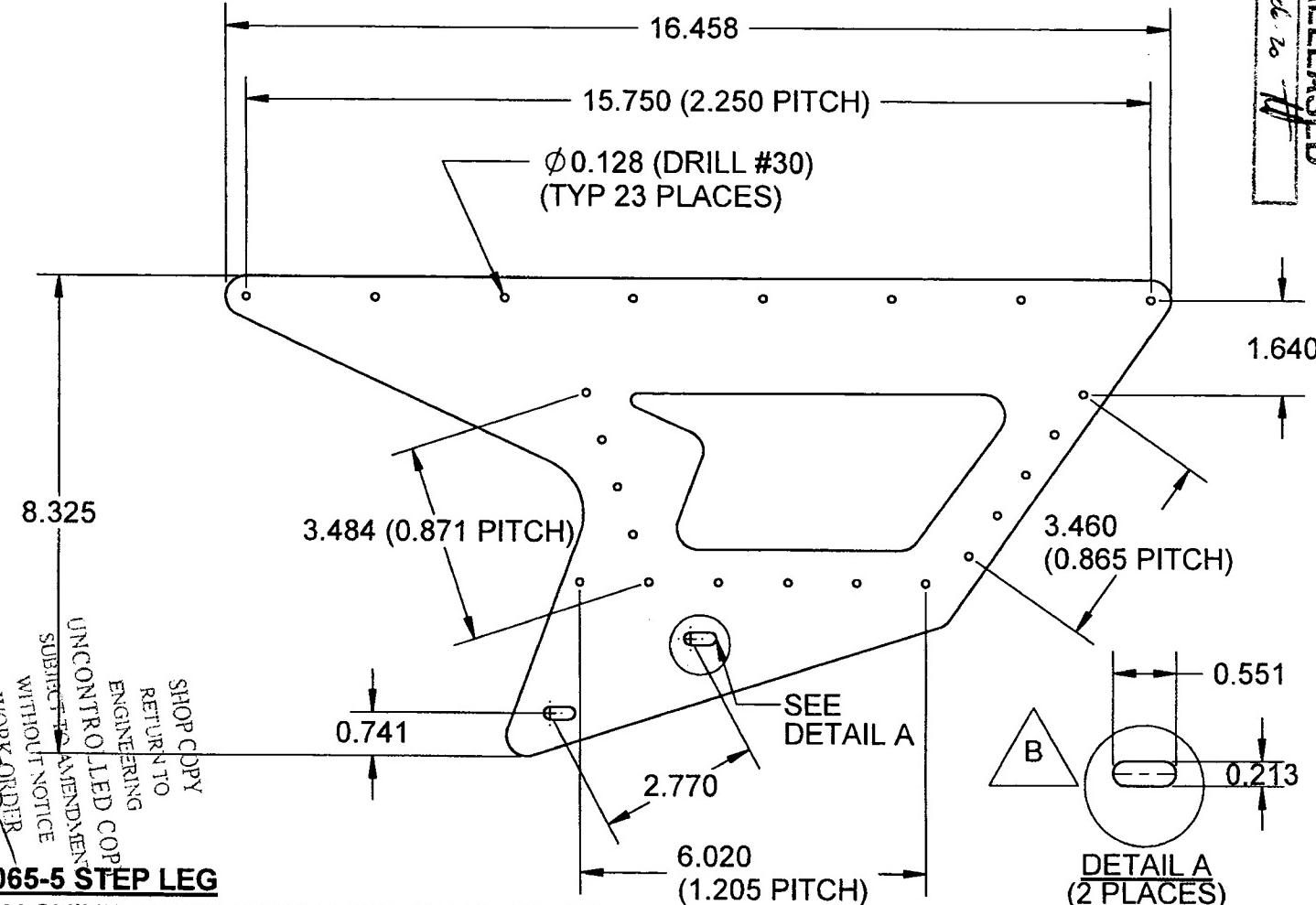


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CHECKED <i>PH</i>	APPROVED <i>JH</i>	DRAWING NO. D3065
DATE 06.05.23	TITLE STEP LEG ASSEMBLY	REV. B SHEET 4 OF 5 SCALE 1:3

**D3065-5 STEP LEG**

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)
OR
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

DART

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CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. D3065	REV. B SHEET 5 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY	SCALE 1:1	

